

Work Order ID 85556

Monday, June 11, 2012 10:07:53 AM

85556

Page 1

Item ID: D4277-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Rib

Stop ***NS2***

Start Date: 6/8/2012 Start Qty: 2.00

Required Date: 6/22/2012 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

2 *6x*
3 *Cpl*

Approvals: Process Plan: MLJ Date: 12/06/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4277	D								

100

0.00

100

Large Fab

Large Fab

Memo

~~AT 26" and BENE TO 15"~~
1- Cut tube as per dwg D4277
2- Remove marking, deburr

0.00

6x *Ø* *Cpl* *12.06.13*

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Quality Control

Memo

0.00

6x *Ø* *Cpl* *12.06.14*

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Packaging

Memo

STOCK IN BASKET CELL

0.00

6x *Ø* *Cpl* *12.06.14*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85556

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Page 2

Monday, June 11, 2012 10:07:53 AM

Item ID: D4277-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib
 Start Date: 6/8/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/22/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/06/14 *[Signature]*

MF
12-06-14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, June 11, 2012 10:07:52 AM

Page 1

Work Order ID: 85556

Parent Item: D4277-7

Parent Item Name: Rib

Start Date: 6/8/2012

Required Date: 6/22/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
REV.C DD verf:EC

IPP Rev:B 11.01.20 AS PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	787.0237	0.1442	0.3035789			

Location

Loc Qty

Loc Code

MAT034

787.0236723

118460

0.00001534

121328

2.970794

121565

198.052863

121808

586

.9188

PL 12-06-13

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

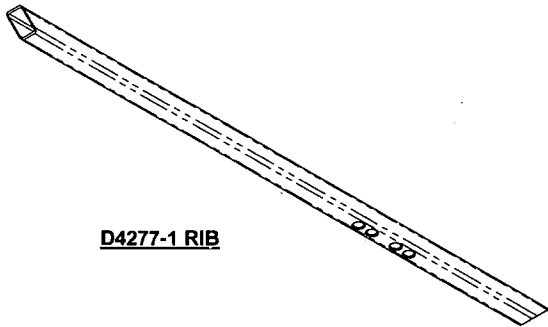
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

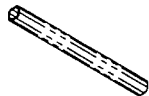
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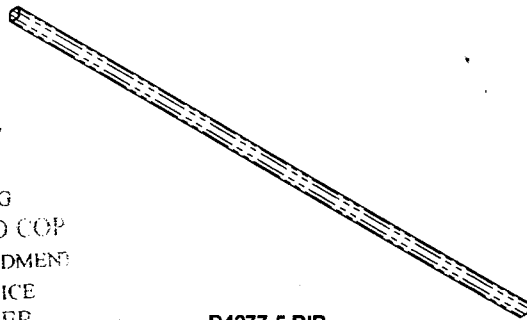
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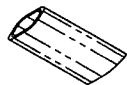
D4277-1 RIB



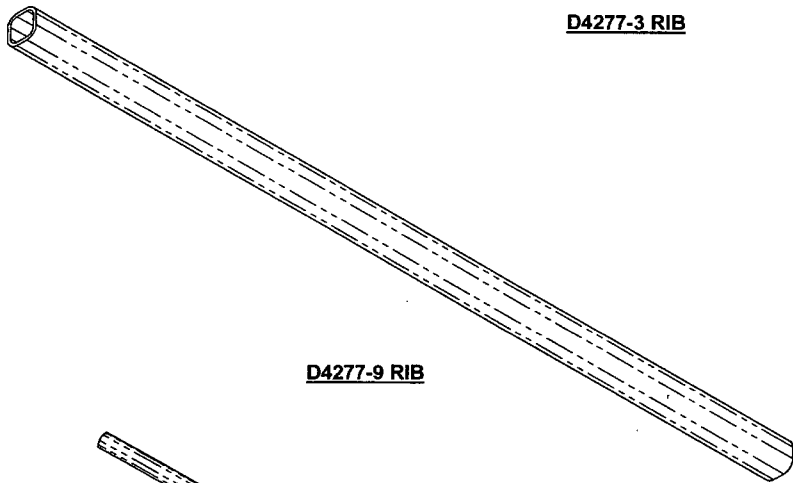
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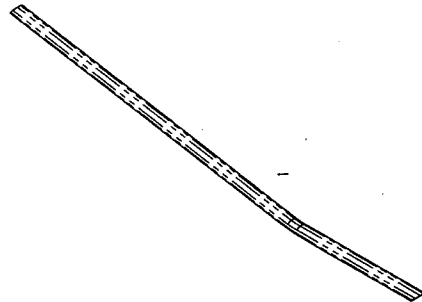
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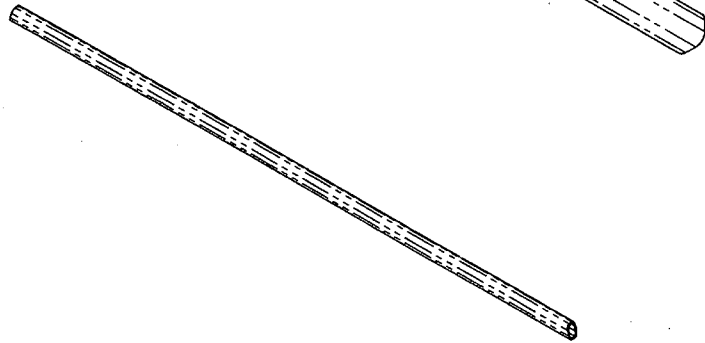
D4277-7 RIB



D4277-9 RIB



D4277-11 RIB



D4277-19 RIB



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COP
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85556 MLJ
12/06/12

RELEASED
2011-02-24
MD

D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV. 13/15/17 (OBSOLETE); -3: 8.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 20.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4277 TITLE RIBS REV. D SHEET 1 OF 3 SCALE NTS	
DRAWN	SC		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

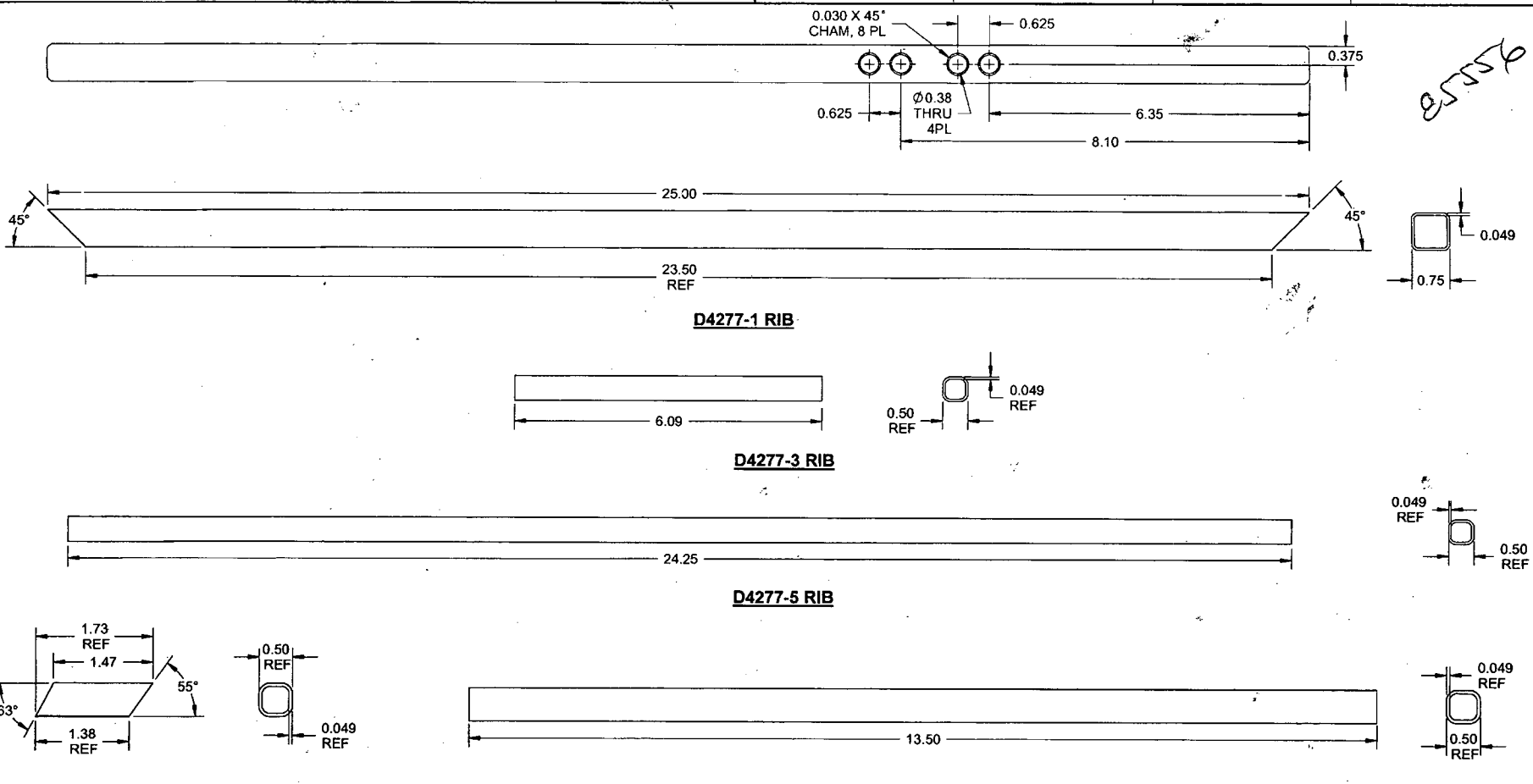
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NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL
 - 1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	SC	DRAWING NO.	REV. D
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DE APPR.		RIBS	NTS
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2011-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

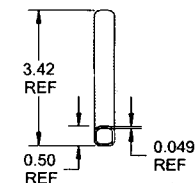
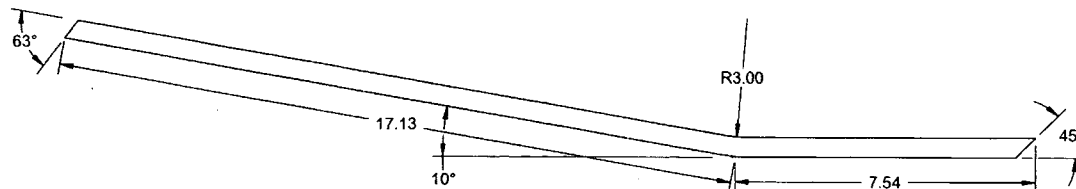
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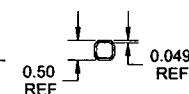
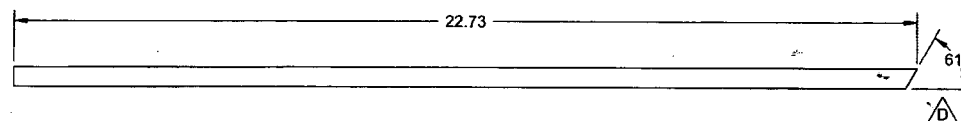
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85756



D4277-11 RIB





D4277-19 RIB

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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CHECKED	K	DRAWING NO.	REV. D
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